Work Order ID 66919

Wednesday, March 02, 2011 2:48:37 PM

Item ID: D4191-15
Revision ID: PRELIM
Item Name: Rack Cover

Accept

Setup Start
Stop

Start Date: 3/2/2011 **Start Qty:** 2.00
Required Date: 3/25/2011 **Req'd Qty:** 2.00
Reference:

Cust Item ID:
Customer:

Run Start
Stop

Approvals: **Process Plan:** CZ **Date:** 11/03/02 **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	**Revision Nbr**								
D4191	~~PAT~~ PA6								
100	DOOSAN LATHE	0.00				2			
Doosan	**Memo**	0.00							
Doosan Lathe	1- Turn as per Folio FA990 Folio Rev: n/a Dwg Rev: PA6 3-Deburr per dwg								
110	QC2- Inspect parts off machine FAI/FAIB	0.00				2			
QC	**Memo**	0.00							
Quality Control									

MATERIAL CERTIFICATION REQ'D UPON DELIVERY

POSITIVE RECALL

PRELIMINARY ISSUE

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

H:\FORMS\Quality Assurance\approved QA\NCRWO RevE

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	QC8- Inspect parts - second check	0.00				2	~~0~~		
QC	Memo	0.00							
Quality Control									
150	Chemical Conversion Coat per QSI005 4.1	0.00				2	BR 11-3-30		
HandFinish	Memo	0.00							
Hand Finishing									
160	QC3- Inspect Part Finish	0.00				2	0	11/03/30	
QC	Memo	0.00							
Quality Control									

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

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Stop

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	Identify as per dwg & Stock Location:_____	0.00							
Packaging	Memo HARRY	0.00					11/7/18	2	
Packaging									
190	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

RD2334

11-07-18

POSITIVE RECALL
EFFECTIVE 11.03.02 AUTH
RELEASED _____ DATE _____

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Wednesday, March 02, 2011 2:48:33 PM

Work Order ID: 66919

Parent Item: D4191-15

Parent Item Name: Rack Cover

Start Date: 3/2/2011 **Required Date:** 3/25/2011

Start Qty: 2.00 **Required Qty:** 2.00

Comments: IPP REV:A NEW ISSUE 10-10-30 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6R0.750 6061-T6 Round Bar .750"		Purchased	No			100	f	46.1898	0.33333	0.701747			

Location		Loc Qty	Loc Code	
MAT		46.173		
	115469	0.0027		
	115869	2.4453		
	116406	43.725		.333
MAT012		0.016842105		
	112442	0.01684211		all

.749

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

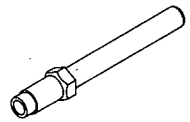
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

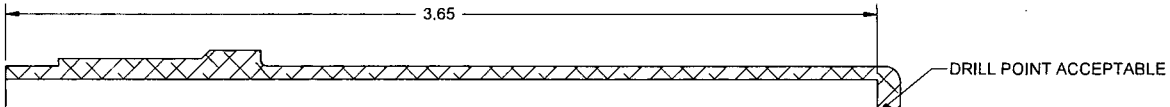
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

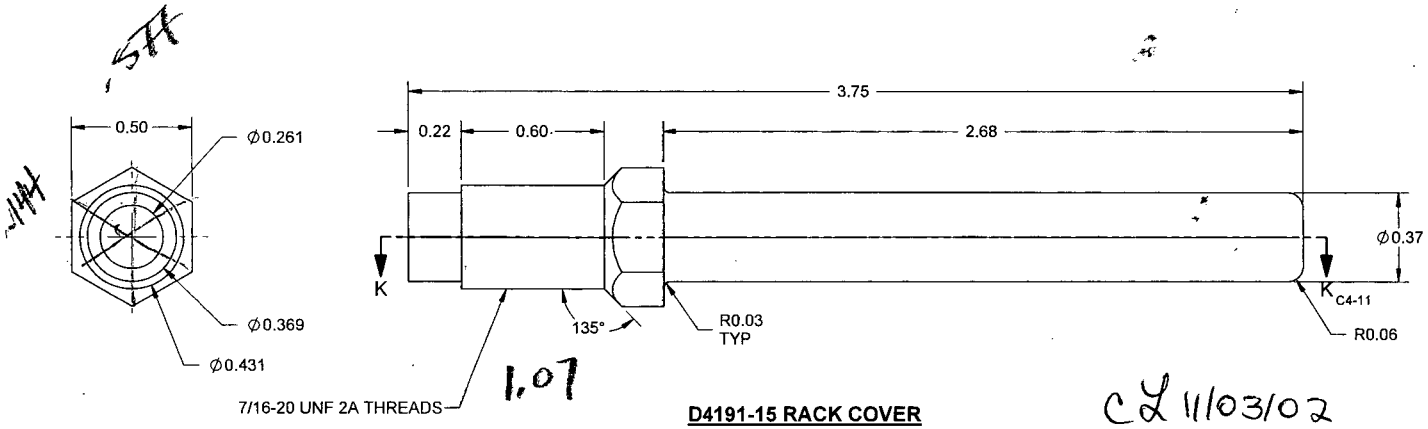
NOTE: Date & initial all entries

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE





SECTION K-K B4-11



D4191-15 RACK COVER

CL 11/03/02

W/O: 66919

NOTES:
1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8
OR AMS 4117/4128/4115/4116
OR QQ-A-200/8 OR AMS-QQ-A-200/8
OR AMS 4160
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6B
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.02 lbs

PRELIMINARY ISSUE
10.11.17

DESIGN		**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA
DRAWN		
CHECKED		DRAWING NO. D4191 — REV. PA6 — SHEET 11 OF 12
MFG. APPR.		
APPROVED		TITLE: CONTROL BOX — SCALE: NTS
DE APPR.		
DATE 10.11.17		

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DART AEROSPACE LTD	Work Order:	66919
Description: RACK COVER	Part Number:	D4191-15
Inspection Dwg: , Rev:		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

[X] First Article [X] Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.65	+/- .030	3.620	✓		RQ-02	
.50	+/- .030	.499	✓			
.261	+.006 -.001	.264	✓			
.369 Ø	+/- .010	.364	✓			
.431 Ø	+/- .010	.431	✓			
3.75	+/- .030	3.750	✓			
.22	+/- .030	.220	✓			
.60	+/- .030	.600	✓			
2.68	+/- .030	2.676	✓			
R.03	+/- .030	2.015	✓			
.37 Ø	+/- .030	.368	✓			
R.06	+/- .030	R.05	✓			
7/16-20	2A	2A	✓			
Major Ø	.4362/.4281	.431	✓	RQ-06		
M.O.W.	.4474/.4432	.445	✓		RQ-06	

Measured by:		Audited by:		Prototype Approval:	
Date:	11.3.30	Date:	11/03/30	Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	